

Work Order ID 69979

Wednesday, May 25, 2011 9:04:50 AM



Page 1

Item ID: D206-667-247TRN

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Assembly, Mid Aft

Start Date: 5/25/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/24/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-25

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|--------------|--------------|
| D206-667-247 | A |

100 0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DTxxxx on both ends as per Folio FB030
2-Turn first side as per Folio FB030
3-File down transition lines smooth.

M.M.C 11/06/22

110 0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

and 11/06/23

120 0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FB030
2-File down transition lines smooth.
3-Remove sand and plugs

M.M.C 11/06/22

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 69979

Wednesday, May 25, 2011 9:04:50 AM

Page 2

Item ID: D206-667-247TRN

Accept

Revision ID:

Item Name: Crosstube Assembly, Mid Aft

Start Date: 5/25/2011 Start Qty: 1.00

Required Date: 6/24/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---|--|----------------------|---------|--------------------|--------------|---------------|---------------|------------------|----------------|
| 130  QC Quality Control | QC1- Inspect dimensions to dimension sheet Memo | 0.00 0.00 | | 05/11/06/23 | | 1 | 2 | | |
| 140  QC Quality Control | QC8- Inspect parts - second check Memo | 0.00 0.00 | | 11/5/23 | | 1 | | | |
| 150  HandFXtube Hand Finishing Crosstubes | Crosstubes Chemical Conversion Memo | 0.00 0.00 | | JW SAD 11-06-27 | | (1) | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 25, 2011 9:04:57 AM

Page 1

Work Order ID: 69979

Parent Item: D206-667-247TRN

Parent Item Name: Crosstube Assembly, Mid Aft



Start Date: 5/25/2011

Required Date: 6/24/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 11.01.06 new issue DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| D6004-115  | | Manufactured | No | | | 100 | Each | 34.0000 | 1 | 1 | | | |
| Crosstube Material | | | | | | | | |  | | | | |

Location

Loc Qty

Loc Code

LG

34

34685

5

38336

29

mm.l 11/06/21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

| | | |
|--|---------------|----------------------------------|
| DART AEROSPACE LTD | | Work Order: 69979 |
| Description: Crosstube Assembly | | Part Number: D200-667-247 |
| Inspection Dwg: | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| Inspection Sheet | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|------------------|-------------------|------------------|------------------|--------|--------|----------------------|----------|
| SIDE A | 2.490 | +0.005 -0.000 | 2.494 | ✓ | | mic | CNC-01 |
| | 2.025 | ±0.005 | 2.030 | ✓ | | " | |
| | 2.074 | ±0.005 | 2.084 | ✓ | | " | |
| | 2.145 | +0.005 -0.000 | 2.150 | ✓ | | " | |
| | 2.209 | +0.005 -0.000 | 2.213 | ✓ | | " | |
| | 2.287 | +0.005 -0.000 | 2.296 | ✓ | | " | |
| | 2.363 | +0.005 -0.000 | 2.363 | ✓ | | " | |
| | 0.200 | ±0.010 | .200 | ✓ | | vern | JF-01 |
| | 4.438 | ±0.030 | 4.468 | ✓ | | " | |
| | R0.063 | ±0.010 | .063 | ✓ | | RG | |
| | R2.00 | ±0.010 | .200 | ✓ | | " | |
| | R0.063 | ±0.010 | .063 | ✓ | | " | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| SIDE B | 2.490 | +0.005 -0.000 | 2.493 | ✓ | | mic | CNC-04 |
| | 2.025 | ±0.005 | 2.030 | ✓ | | " | |
| | 2.074 | ±0.005 | 2.084 | ✓ | | " | |
| | 2.145 | +0.005 -0.000 | 2.150 | ✓ | | " | |
| | 2.209 | +0.005 -0.000 | 2.213 | ✓ | | " | |
| | 2.287 | +0.005 -0.000 | 2.290 | ✓ | | " | |
| | 2.363 | +0.005 -0.000 | 2.364 | ✓ | | " | |
| | 0.200 | ±0.010 | .200 | ✓ | | vern | JF-01 |
| | 4.438 | ±0.030 | 4.468 | ✓ | | " | |
| | R0.063 | ±0.010 | .063 | ✓ | | RG | |
| | R2.00 | ±0.010 | .200 | ✓ | | " | |
| | R0.063 | ±0.010 | .063 | ✓ | | " | |
| | | | | | | | |
| | | | | | | | |
| | | | | | | | |
| | 99.76 | ±0.020 | 99.76 | ✓ | | type | mm-L-02 |

| | | |
|----------------------------|--------------------------------|------------------------------|
| Measured by: gmm/px | Audited by: [Signature] | Preliminary Approval: |
| Date: 11/06/21 | Date: 11/6/23 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| B | 10.04.14 | Added preliminary approval | KJ | |

10.04.15

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

| Item | Qty -247 | Part Number | Description |
|------|-------------|----------------|--|
| 1 | X | D206-667-247 | CROSSTUBE ASSEMBLY (206L MID AFT) |
| 2 | 1 | D6004-115 | CROSSTUBE |
| 3 | 2 | D2873-043 | NUT PLATE |
| 4 | 2 | D2873-045 | NUT PLATE |
| 5 | 2 | D2892-1 | SUPPORT |
| 6 | 4 | D3595-063-450 | RUBBER CUSHION |
| 7 | 4 | MS21920-22 | CLAMP |
| 8 | 14 | MS20601AD4W10 | RIVET (OR NAS9302B-4-10) |
| 9 | A/R | MAGNOBOND 6398 | ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299- 947-100, TYPE II, CLASS 2 ADHESIVE) |

GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6004-115
FINISHED LENGTH = 99.76±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-247" AND BATCH NUMBER ON
INSIDE OF CLIFF PER DART QSI 044 6.4 (VIBRATING STYLUS).
- 7) WEIGHT: 21.1 lbs (-607 = 17.7 lbs)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY,
TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 10 PASSES. MAXIMUM TUBE FLATTENING DUE
TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2892-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI
015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-22 CLAMPS WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE
D2892-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE
LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE
OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS
SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT
LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN
SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. *6979*

2/11-05-25
RELEASED
2011-05-24

| | | | | |
|------------|-----------|-------------|----|----------|
| A | NEW ISSUE | DESCRIPTION | CP | 10.12.23 |
| REV. | | | BY | DATE |
| DESIGN | | | | |
| DRAWN | <i>9</i> | | | |
| CHECKED | <i>9</i> | | | |
| MFG. APPR. | <i>9</i> | | | |
| APPROVED | <i>9</i> | | | |
| DE APPR. | <i>9</i> | | | |
| DATE | 10.12.23 | | | |

| | |
|--|------------------------|
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWING NO. D206-667-247 | REV. A SHEET 1 OF 4 |
| TITLE CROSSTUBE ASS'Y (206L MID AFT) | SCALE NTS |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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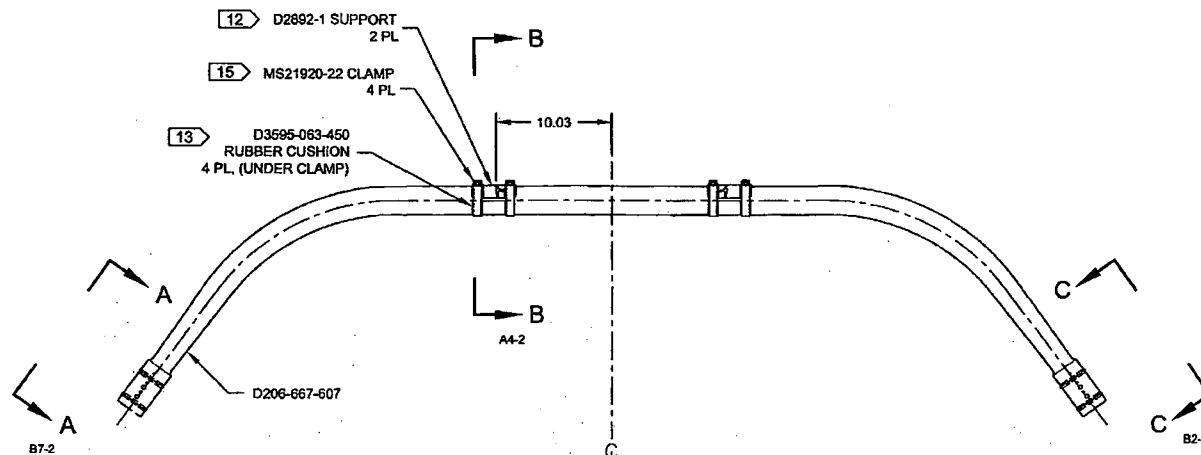
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

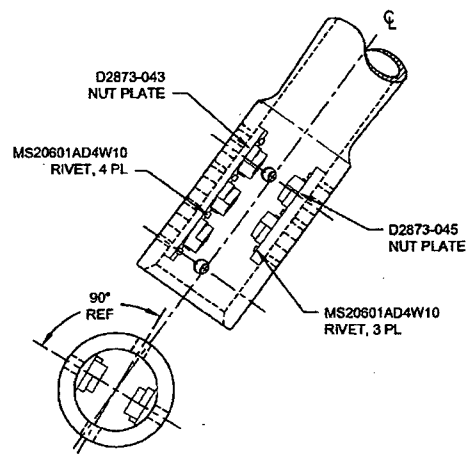
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NOTE: Date & initial all entries

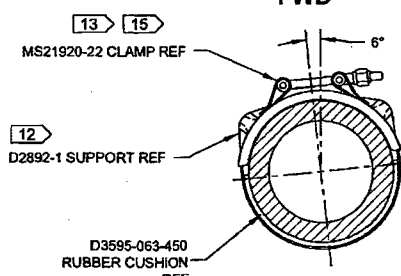
8 7 6 5 4 3 2 1



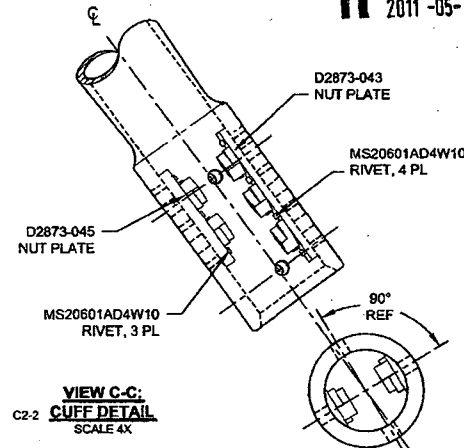
**D206-667-247
 ASSEMBLY DETAIL
 (VIEW LOOKING FWD)**



**VIEW A-A:
 CUFF DETAIL
 SCALE 4X**



**D5-2 SECTION B-B
 SCALE 5X**



**VIEW C-C:
 CUFF DETAIL
 SCALE 4X**

| | | | |
|------------|----------|---|--------------|
| DESIGN | 97 | DART AEROSPACE LTD | |
| DRAWN | 97 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D206-667-247 | SHEET 2 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | CROSSTUBE ASS'Y (206L MID AFT) | NTS |
| DATE | 10.12.23 | <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

8 7 6 5 4 3 2 1

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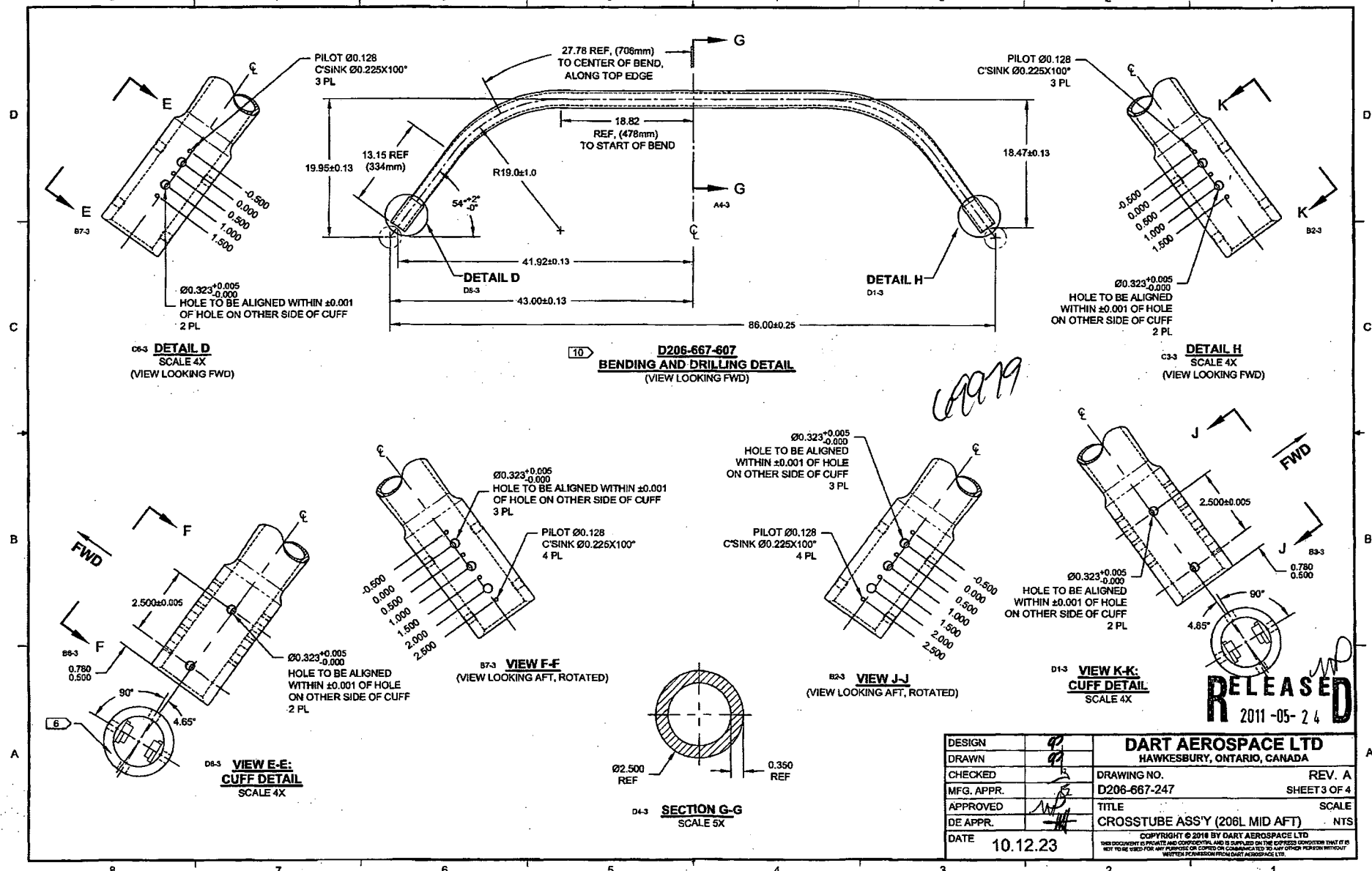
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NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



RELEASED
2011-05-24

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|------------|----------|------------------------------------|
| DESIGN | | DART AEROSPACE LTD |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | | DRAWING NO. REV. A |
| MFG. APPR. | | D206-667-247 SHEET 3 OF 4 |
| APPROVED | | TITLE SCALE |
| DE APPR. | | CROSSTUBE ASS'Y (206L MID AFT) NTS |
| DATE | 10.12.23 | |

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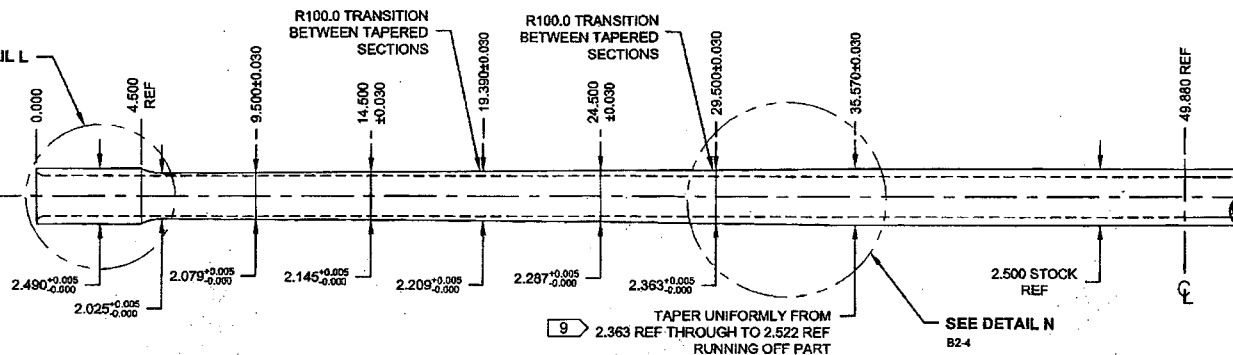
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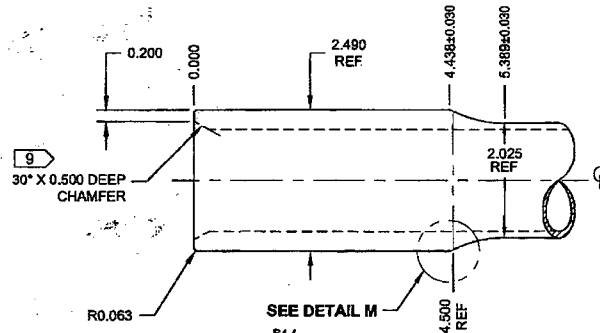
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

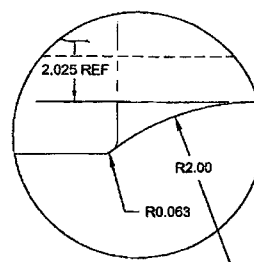
SEE DETAIL L
B7-4



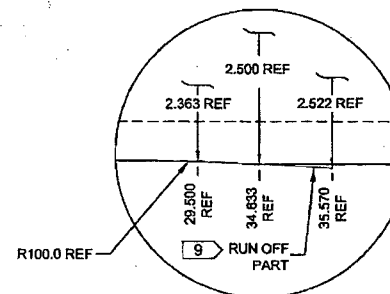
TURNING DETAIL



C7-4 **DETAIL L: CROSSTUBE CUFF**
SCALE 2.5X



B6-4 **DETAIL M: CUFF TRANSITION**
NOT TO SCALE



C4-4 **DETAIL N: TAPER RUN-OFF**
NOT TO SCALE

RELEASED
2011-05-24

| | | | |
|------------|----------|--|--------------|
| DESIGN | 9 | DART AEROSPACE LTD | |
| DRAWN | 9 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 9 | DRAWING NO. | REV. A |
| MFG. APPR. | 9 | D206-667-247 | SHEET 4 OF 4 |
| APPROVED | 9 | TITLE | SCALE |
| DE APPR. | 9 | CROSSTUBE ASS'Y (206L MID AFT) | NTS |
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